

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022369**Date Inspected:** 25-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr. Geng Wei		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No
<b>Weld Procedures Followed:</b>	Yes	No
<b>Verified Joint Fit-up:</b>	Yes	No
<b>Approved WPS:</b>	Yes	No
<b>Delayed / Cancelled:</b>	Yes	No

**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 12BE / Trial Assembly

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG Segment 12BE welds as per ZPMC notification # 08612.

The weld designations reviewed are as follows:

SEG3001F-133, 134,  
CA3003C-075, 076, 063, 064, 100, 035, 138  
DP3021-001-039~043  
SEG3001D-132, 133  
CA3003D-262, 262, 215, 216, 277, 278  
DP3021-001-170, 171, 135, 136,137, 138, 168  
SEG3003D-092, 093,  
SEG3003D- 133, 134  
CA3005C-061, 062, 015, 016, 001, 002, 151, 152, 203, 204  
SEG3003L-131, 132

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OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3019M-010. The welder is identified as 501946. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic\_001.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3019U-001. The welder is identified as 058102. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic\_001.

OBG Segment 13CE / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3011U-007. The welder is identified as 067656. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic\_001

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-177. The welder is identified as 054013. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-155. The welder is identified as 044779. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-133. The welder is identified as 215553. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

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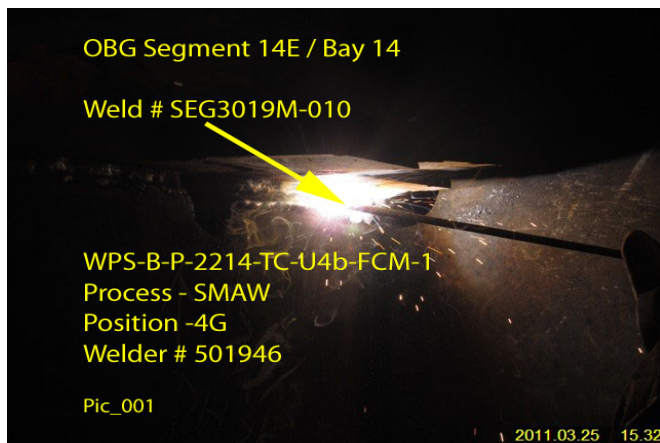
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-089. The welder is identified as 216086. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-111. The welder is identified as 043661. Quality Control (QC) is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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